

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009374**Date Inspected:** 30-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following work in progress:

During random visual inspection of welding this QA inspector found isolated porosity in a total of sixteen(16) locations, measured to be from 3~7mm in diameter in the floor beam flange weld# FB3002-001-002 and FB3053-001-010. This QA inspector notified ZPMC QC Yang Qing Feng of this issue. These weld joints were welded by flux core arc welding process. For more information please find attached pictures.

Bay#2

FCAW welding of weld joint FB3002-001-027, 028, 032, 031 located on FB3002-001. Welder is identified as 206358(2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of weld joint FB3053-001-004, 013, 014, 029, 030, 022 located on FB3053-001. Welder is identified as 045203(2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of weld joint FB6501-001-002, 015, 016, 021, 022 located on FB6501-001. Welder is identified as 045203(2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3.

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SAW welding of weld joint Seg061*-006 located on Segment10BW. Welder is identified as 250050 (1G). ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-BL2c-S-2.

Bay#3

FCAW welding of weld joint CA084-057, 058 located on Corner Assembly 084. Welder is identified as 44790(3G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

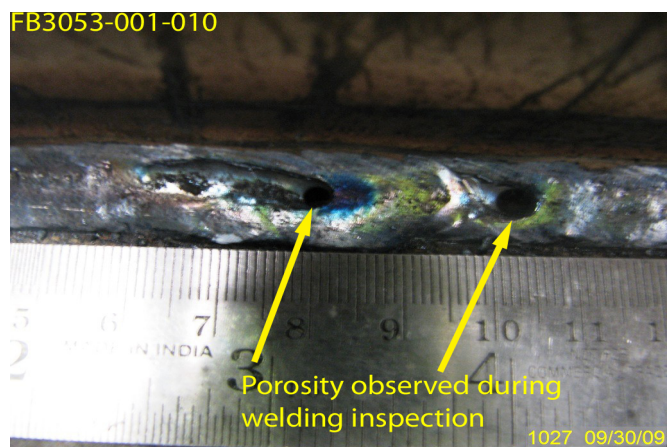
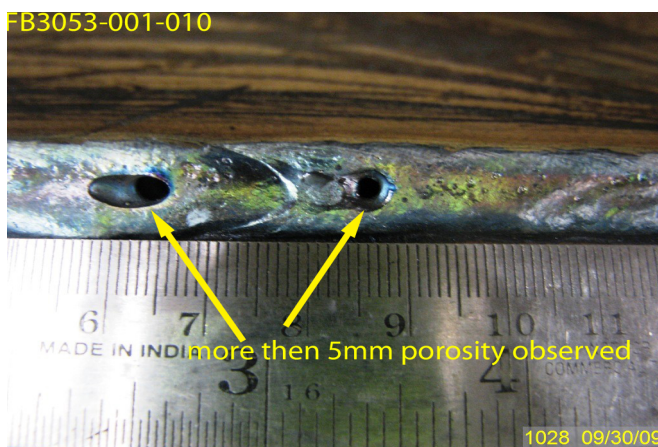
FCAW welding of weld joint CA088-069, 070 located on Corner Assembly 088. Welder is identified as 44790(3G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint CA081-021, 022 located on Corner Assembly 081. Welder is identified as 44790(3G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint CA080-033, 034, 045, 046 located on Corner Assembly 080. Welder is identified as 44790(3G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

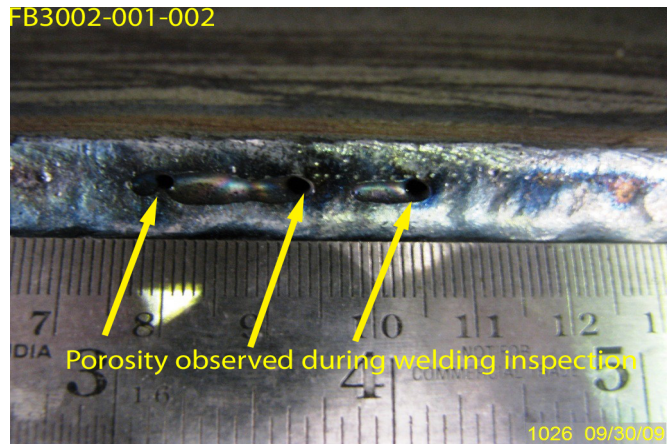
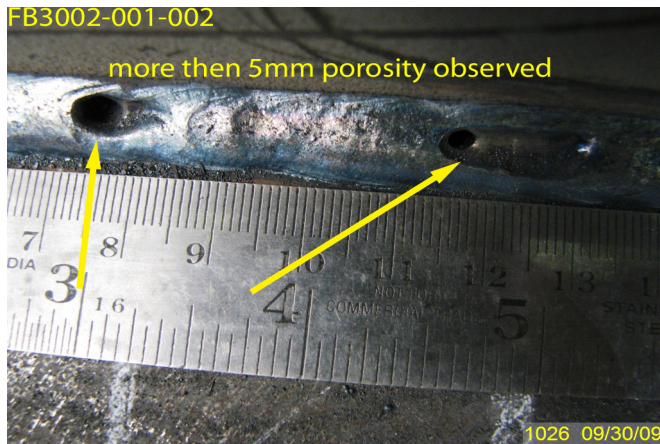
FCAW welding of weld joint CSD3-PP098-098, 099, 104 located on CSD3-PP098. Welder is identified as 208035 (2G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



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Item	Description	WBS	Dwg No.	Status
1				

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Whitehead,Lonnie	QA Reviewer
